






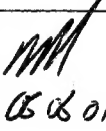
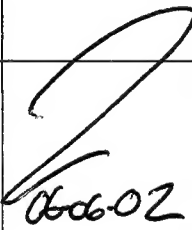

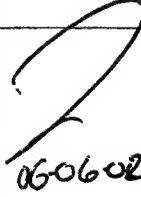


Date: Wednesday, 5/31/2006 10:59:40 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 26800	
Estimate Number : 10227	
P.O. Number : N/A	Part Number : D2151
This Issue : 5/31/2006 S.O. No. : N/A	Drawing Number : D2151 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : 4/25/2006 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 25156	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 5/1/2006
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	Qty: 96 Um: Each
Comment : Est C 00.10.23 Re-format (mpp 2101) EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M2024T3S040 2024-T3 .040 sheet
	
Comment: Qty.: 0.0368 sf(s)/Unit Total : 3.5280 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: <u>M19295</u> <u>MA 05 31</u>	
2.0	SHEAR SHEAR
	
Comment: SHEAR Cut blank: 2.194" x 2.300" +/-0.005"	
3.0	HAAS+ <u>Warden jet</u> HAAS CNC VERTICAL MACHINING #1
	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA110 and Dwg D2151 Identify as D2151 Prog rev: <u>A</u> Dwg rev: <u>A</u> <u>MA 05 (31)</u> <u>PTD</u>	
4.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>06.06.02</u> <u>(50)</u>	
5.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>En 06.06.02</u> <u>(50)</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
		STEP 48 PCS. 40 + 2						
06-06-02	3	48 - made on a sheet holes way over tolerance. All 48 scrap. + 2 more from replacement stack, holes damaged on water Jet.		48 scrap: destroy, replace. Scrap the 2 parts with damaged holes no replace. Re adjust hole size for W.S. on DXF disc.	 05-06-01	 06-06-02	 06-06-02	 06-06-02

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: \ Wednesday, 5/31/2006 10:59:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 26800

Part Number: D2151

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 06:06:02

50

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06:06:02

50

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

PL 06/06/05

50

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 06 06 05

50

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST026

PL 4/6/5

50

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PL 06/06/07

Job Completion



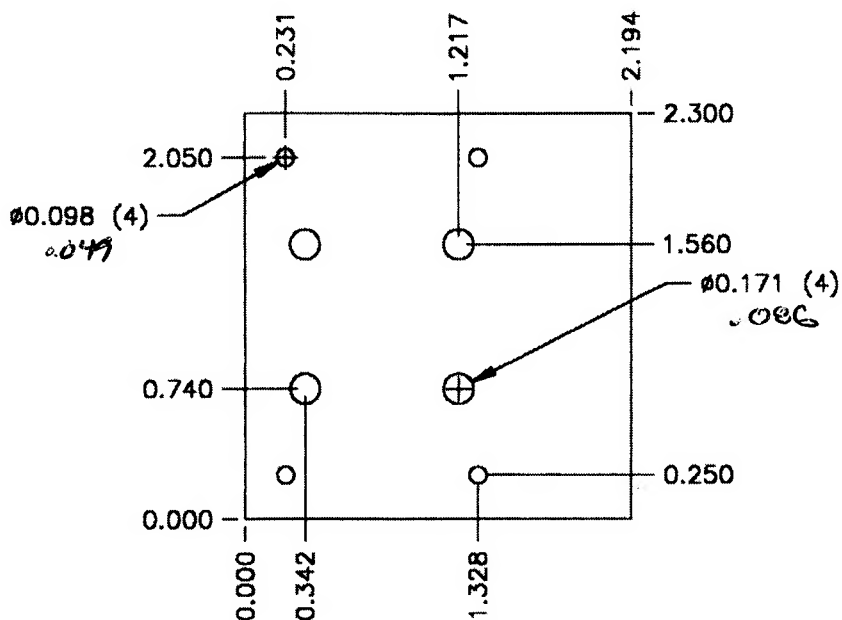
U 06/06/06



DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Bu</i>	APPROVED <i>Bu</i>	DRAWING NO. D2151	REV. A SHEET 1 OF 1
DATE 95:05:01	TITLE PACKER		SCALE 1:1

RELEASED
96/06/13 BW

26 500 ?



REFERENCE ONLY

MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

DART AEROSPACE LTD		Work Order:	26800
Description: Packer		Part Number:	D2151
Inspection Dwg: D2151 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098 0.099	✓	✗	vern	
Ø0.171	+0.005/-0.000	0.176	✓		vern	
0.231	+/-0.010	0.230 0.240	✓	✗	vern	
1.217	+/-0.010	1.209				
2.194	+/-0.010	2.194	✓		vern	
2.300	+/-0.010	2.303	✓		vern	
1.560	+/-0.010	1.558	✓		vern	
0.250	+/-0.010	0.247	✓		vern	
1.328	+/-0.010	1.328 1.338	✓	✗	vern	
0.342	+/-0.010	0.342	✓		vern	
0.740	+/-0.010	0.739	✓		vern	
2.050	+/-0.010	2.045	✓		vern	
0.040	+/-0.010	0.040	✓		vern	

Measured by:	<i>MM</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	06 05 31	Date:	06-06-02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	